

ABSTRACT

The invention relates to a brazing sheet product including a core sheet, on at least one side of the core sheet a clad layer of an aluminum alloy including silicon in an amount in the range of 4 to 14% by weight, and further including on at least one outersurface of the clad layer a plated layer of nickel-tin alloy, such that the clad layer and all layers exterior thereto form a metal filler for a brazing operation and have a composition with the proviso that the mol-ratio of Ni:Sn is in the range of 10:(0.5 to 9). The invention further relates to a method of manufacturing an Al or Al alloy workpiece, which method includes the steps of: (a) providing an Al or Al alloy workpiece, (b) pre-treating the outersurface of the Al or Al alloy workpiece, and (c) plating a metal layer comprising nickel onto said outersurface of the Al or Al alloy workpiece, and wherein during step (c) the metal layer comprising nickel is deposited by plating a nickel-tin alloy using an aqueous plating bath including a nickel-ion concentration in a range of 2 to 50 g/l and a tin-ion concentration in the range of 0.2 to 20 g/l.